

Date: Monday, 5/15/2006 11:11:52 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 L WEB
Job Number	: 27109		
Estimate Number	: 10722		
P.O. Number	: N/A	Part Number	: D26547
This Issue	: 5/15/2006 S.O. No. : N/A	Drawing Number	: D2654 REV E1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 5/15/2006 Type : LANDING GEAR	Drawing Revision	: E1
Previous Run	: 26785	Material	: N/A
Written By	: <i>See Comment Below</i>	Due Date	: 5/30/2006
Checked & Approved By	: <i>06.05.15</i>	Qty:	6 Um: Each
Comment	: Est Rev: D 98.02.04 Fixed typo, Changed procedure DM Est Rev: e 06.04.05 Added level 21 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26007125	Extrusion 'I Beam' thick
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2600-7- 125	Web	321130 25 06-05-19

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-7 to length as per Dwg D2654 25 06-05-19

2-Drill pilot holes in web using drill jig DT 8018-7 as per Dwg D2654 25 06-05-19

3-Using the uni-bit, open holes to finish size as per Dwg D2654 25 06-05-19

4-Deburr holes and ends 25 06-05-19

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

BE 06-05-19 (6)

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1


Chemical Conversion Coat as per QSI 005 4.1 25 06-05-29

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____ PAR #: _____ Fault Category: _____

NOTE: Date & initial all entries

NCR: Yes ☒ No ☐ DQA:  Date: 06/05/30
QA: N/C Closed: _____ Date: _____

Date: Monday, 5/15/2006 11:11:52 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L WEB

Job Number: 27109

Part Number: D26547

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 06-5-29

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: L6

DP 06-5-29

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/05/30 (2)

Job Completion



U 06-05-30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr		Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

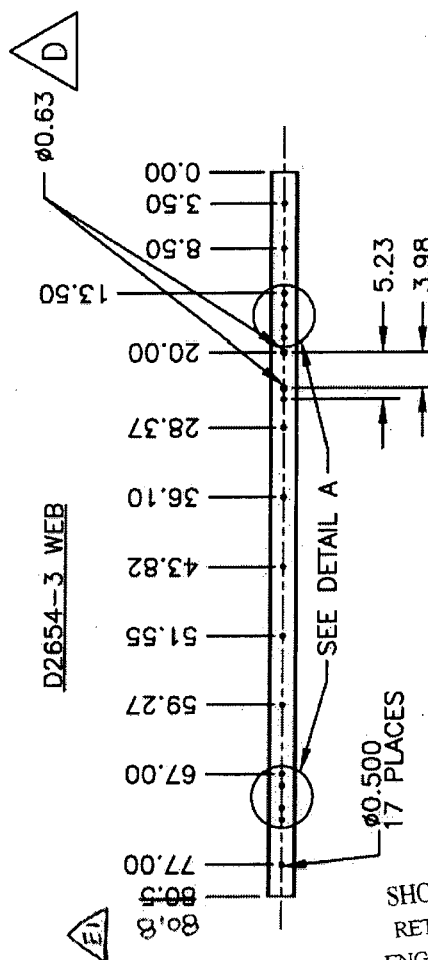
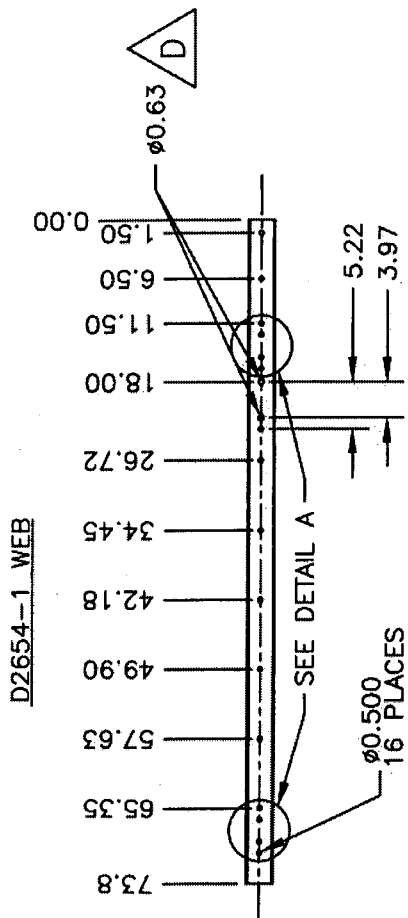
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN <i>CP</i>		DRAWN BY <i>CP</i>		DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED <i>#</i>	APPROVED <i>#</i>		DRAWING NO.		REV. E
				D2654	SHEET 1 OF 2
DATE			TITLE		SCALE
04.05.26			WEB		1:20
A	97.03.25		NEW ISSUE		
B	97.06.26		ALTER HOLE PATRN., 0.500 WAS 0.438		
C	97.10.29		CHANGED HOLE PATTERN		
D	98.01.15		GHW HOLES CHANGED TO $\phi 0.63$		
E	04.05.26		CHANGE LENGTHS, REFORMAT		
E1	<i>CP</i>	04.08.04	PER TOOLING; 80.8 WAS 80.5		

RELEASED
04.06.22



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MAKE FROM D2600-5-108 EXTRUSION
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TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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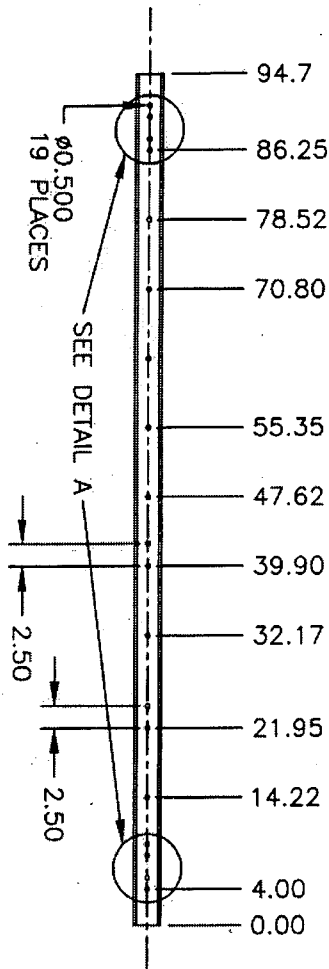
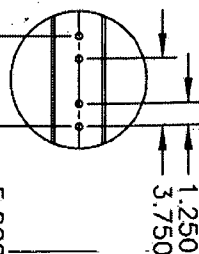
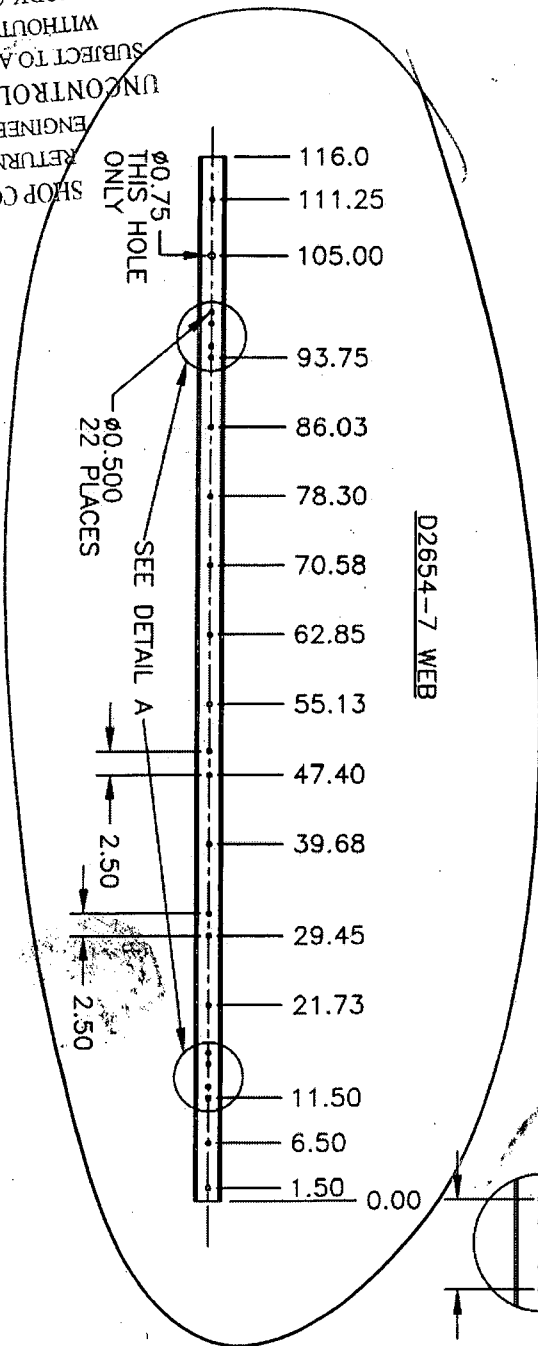
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MAKE FROM D2600-7-125 EXTRUSION
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TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED



RELEASED
04.05.26

DATE	04.05.26	TITLE	WEB	SCALE	1:20
CHECKED		DRAWING NO.	D2654	SHEET 2 OF 2	REV. E
DESIGN		APPROVED		DART AEROSPACE USA, INC.	PORT HADLOCK, WA
DRAWN BY					

